

Date: Thursday, 02/04/2009 2:29:12 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 46897		
Estimate Number	: 13833		
P.O. Number	:	Part Number	: D38951
This Issue	: 02/04/2009 S.O. No. :	Drawing Number	: D3895 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 14/04/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>JUL 09 04 03</u>		
Comment	: Est Rev:A 09.03.06 new issue EC verified by:dd		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S050	6061-T6 .050 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0840 sf(s)/Unit Total: 0.5040 sf(s)

6061-T6 ALUM .050 Sheet

BATCH: 104186 IB 9-4-23

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3895

Dwg Rev: A

Prog Rev: A

IB 9-4-23

(10)

2- Deburr if necessary IB 9-4-23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8 09/04/24

(10)

(PB)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST1398

8 09/04/28 (10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
9/4/27	4.1	Chemical cont Alodine AS per Q57005	MD/BR	09/04/27	10		S 09/04/27	
9/4/27	4.2	inspect Alodine Qc3	JL	09/04/27	10		S 09/04/27	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: - Thursday, 02/04/2009 2:29:12 PM  
User: - Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 46897

Part Number: D38951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/28 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf  
09-04-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 46897
Description: DOUBLER		Part Number: D3895-1
Inspection Dwg: D3895-1 Rev: A		Page 1 of 1

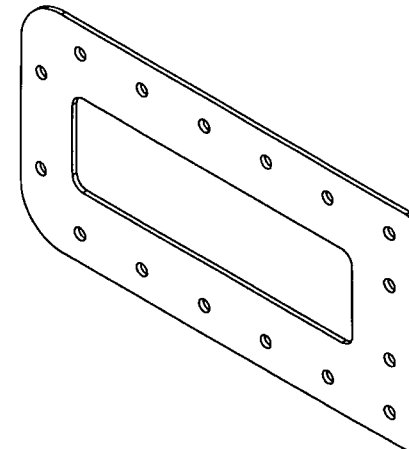
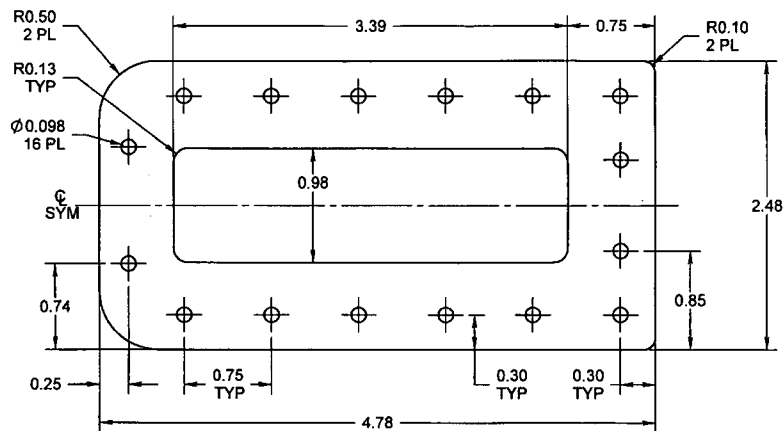
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.099	X			
.74	+/- .030	.740	X			
.25	+/- .030	.250	X			
.75	+/- .030	.751	X			
.30	+/- .030	.306	X			
.30	+/- .030	.304	X			
.85	+/- .030	.851	X			
.98	+/- .030	.973	X			
.75	+/- .030	.751	X			
2.48	+/- .030	2.483	X			
3.39	+/- .030	3.392	X			
4.78	+/- .030	4.781	X			
.050	+/- .010	.048	X			

Measured by: RB	Audited by: S	Prototype Approval: 1/12
Date: 9-4-23	Date: 02/04/24	Date: 1/12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D3895-1 DOUBLER**

**RELEASED**  
09/02/04

A	NEW ISSUE		09.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.04		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3895</b>	REV. A
TITLE <b>DOUBLER</b>	SHEET 1 OF 1
	SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC M6061T6S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3895-1" & B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.04 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 110871